



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2438

Job Sheet 184860



Part No: D2438

Job Qty: 80 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2727 REV A1, D2438 REV C IPP: E 05.06.28 Bending removed KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	80 pcs		11/2/18	0.00	2.82	Waterjet 1		DEC 18 10 27 2018 DAS
120	QC	80 pcs		11/2/18	0.00	0.00	QC8		OCT 22 2018 68
130	Small Fab	80 pcs		11/2/18	0.01	2.75	Small Fab		NOV 20 2018 DAS
140	QC	80 pcs		11/2/18	0.00	0.00	QC5		NOV 20 2018 68
150	Packaging	80 pcs		11/2/18	0.00	0.00	Packaging3		NOV 22 2018 9-89
160	QC21-SA	80 Ea		11/2/18	0.00	0.00	QC21		NOV 22 2018

Part Op 100 - Cut as per dwg D2438 prog rev: A1 dwg rev: AL
Descriptions: 120 - (6.786" center to center)

130 - 1- Use DT9713 clamp holder to hold clamp in place when forming 2- Bend as per dwg using DT9709

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	3.2000 sf (.04 ea)	100-Waterjet	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M304S16GA	3	254	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.750inches ± 0.010	0.760 0.740		
2	Clamp	6.786inches ± 0.010	6.796 6.776		
3	Clamp	7.586inches ± 0.010	7.596 7.576		
4	Clamp	0.063inches ± 0.010	0.073 0.053		
5	Clamp	0.257inches + 0.006 - 0.001	0.263 0.256		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube</td><td>☐</td> <td>Cross tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>Machining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Thermoforming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Large Fab</td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>				Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Large Fab	☐	Composite	☐	Supplier	☐		
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation 	Disposition 	Completed By _____ and / Supervisor _____ Approval Verification _____ A Coordinator _____ Approval _____
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DART AEROSPACE
 Container No: S120106
 Part: D2438
 Job No: 184860
 Serial No/ Batch: S120106
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's
 Date: 10/22/18

1270 Aberdeen Street
 Markham, ON R3A 1K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Root Cause <table> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	FAULT CATEGORY <table> <tr><td>Pressure/Forced</td><td>☐</td><td>Temperature/Cure</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td><td>Set-up</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td><td>BOM/Route</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incomplete/Unqualified</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incomplete/Unclear</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td></tr> </table>		Pressure/Forced	☐	Temperature/Cure	☐	Bending	☐	Set-up	☐	Centre Not Concentric	☐	BOM/Route	☐	Cracks	☐	Broken/Damage/Defect	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Cuffs	☐	Contamination	☐	Crushing	☐	Countersink	☐	Heat Treat	☐	Cut Too Short	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Marks/Chatter	☐	Drill Holes	☐
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